

Date: Thursday, 5/31/2007 7:23:02 AM
 User: Kim Johnston

Process Sheet

26

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : HELI-ACCESS STEP RH (FOLDING)
Job Number : 32716	
Estimate Number : 12568	
P.O. Number : N/A	Part Number : D412630034
This Issue : 5/31/2007 S.O. No. : N/A	Drawing Number : IIN D412-630 REV K
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : LARGE FAB ASSY	Drawing Revision : K
Previous Run : 32714	Material : N/A
Written By : <u>JA</u>	Due Date : 6/30/2007 Qty: <u>5</u> Um: Each
Checked & Approved By : <u>JA 07.05.31</u>	
Comment : Est. Rev.A New Issue 06-11-08 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	DC	DOCUMENT CONTROL
-----	----	------------------



Comment: DOCUMENT CONTROL

Photocopy bluefile & create labels per PPP D412-630-034 CHG002

KS 07.06.05 (6)

2.0	D2012107	Clevis
-----	----------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Clevis

Pick:

Qty	Part Number	Description
1	D2012-107	Clevis

Batch

32551

SD

3.0	D2803042	Bracket Assembly
-----	----------	------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Bracket Assembly

Pick:

Qty	Part Number	Description
1	D2803-042	Bracket Assembly RH

Batch

27283

26564 27392

4.0	D2804042	Bracket Assembly
-----	----------	------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Bracket Assembly

Pick:

Qty	Part Number	Description
1	D2804-042	Bracket Assembly RH

Batch

27409, 27284, 7/7/11 SD

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 5/31/2007 7:23:02 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS STEP RH (FOLDING)

Job Number: 32716

Part Number: D412630034

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D2807

Support Prop



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Support Prop

Pick:

Qty	Part Number	Description
2	D2807	Gas Spring

Batch

1529828

SD

6.0

D2813

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description
2	D2813	Washer

Batch

1529396

SD

7.0

D3562042

STEP ASSEMBLY, RH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Step Weldment LH

Pick:

Qty	Part Number	Description
1	D3562-042	Step Weldment RH

Batch

B32721

8.0

D33951

Bushing



Comment: Qty.: 4.0000 Each(s)/Unit Total : 24.0000 Each(s)

Bushing

Pick:

Qty	Part Number	Description
4	D3395-1	Bushing

Batch

1528455

26770

32783

SD

4 *

10X

9.0

AN3C21A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

BOLT

Pick:

Qty	Part Number	Description
2	AN3C21A	Bolt

Batch

1101189, 7/7/1150

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Date: Thursday, 5/31/2007 7:23:02 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS STEP RH (FOLDING)

Job Number: 32716

Part Number: D412630034

Job Number:



Seq. #:

Machine Or Operation:

Description:

10.0

AN8C16

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 12.0000 Each(s)

Bolt

Pick:

Qty	Part Number	Description
2	AN8C16	Bolt

Batch

M102736

SP

11.0

AN310C8

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total: 12.0000 Each(s)

Nut

Pick:

Qty	Part Number	Description
2	AN310C8	Nut

Batch

M102728

M104679

SP

3

12.0

MS24665302

Cotter Pin



Comment: Qty.: 2.0000 Each(s)/Unit Total: 12.0000 Each(s)

Cotter Pin

Pick:

Qty	Part Number	Description
2	MS24665-302	Cotter Pin (or AN380C3-4)

Batch

M16941

SP

13.0

NAS1515H3

Washer



Comment: Qty.: 6.0000 Each(s)/Unit Total: 36.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description
6	NAS1515H3	Washer

Batch

M102993

SP

14.0

NAS1515H5L

WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total: 24.0000 Each(s)

WASHER

Pick:

Qty	Part Number	Description
4	NAS1515H5L	Washer

Batch

M104679

7/7/11 SP

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Date: Thursday, 5/31/2007 7:23:03 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS STEP RH (FOLDING)

Job Number: 32716

Part Number: D412630034

Job Number:



Seq. #:

Machine Or Operation:

Description:

15.0

NAS1515H8

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total: 24.0000 Each(s)

Washer

Pick:

Qty Part Number

Description

Batch

4 NAS1515H8

Washer

M102067

sd

16.0

MS210433

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total: 24.0000 Each(s)

Nut

Pick:

Qty Part Number

Description

Batch

4 MS21043-3

Nut

M104679

sd

17.0

MS24693C280

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total: 12.0000 Each(s)

Screw

Pick:

Qty Part Number

Description

Batch

2 MS24693-C280

Screw (or MS24694-C565)

M101390

7/2/11 SG

18.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg D412-630 p.14

Coat all hardware with LPS3 rust inhibitor

A/R LPS3 batch: M104929

COAT exposed HARDWARE WITH LPS PROCYON.

A/R LPS PROCYON

BATCH: M17045

MF 07-07-18

19.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

LC 07/07/18 (5)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 5/31/2007 7:23:03 AM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS STEP RH (FOLDING)

Job Number: 32716

Part Number: D412630034

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

21.0

D28061

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Bushing

Pick: Packing Kit

Qty Part Number

Description

Batch

2

D2806-1

Bushing

327285 ✓

26565 ✓

29393 ✓

22.0

D28063

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Bushing

Pick: Packing Kit

Qty Part Number

Description

Batch

2

D2806-3

Bushing

26162 ✓

27286 ✓

28163 ✓

32939 ✓

23.0

D28105

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Strut

Pick: Packing Kit

Qty Part Number

Description

Batch

1

D2810-5

Strut

327103 ✓

327287 ✓

32939 ✓

24.0

D33961

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Spacer

Pick: Packing Kit

Qty Part Number

Description

Batch

2

D3396-1

Spacer

327297 ✓

327290 ✓

32939 ✓

25.0

AN4C6A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Bolt

Pick: Packing Kit

Qty Part Number

Description

Batch

M104936 ✓

2/6/23 SQ ✓

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 5/31/2007 7:23:03 AM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS STEP RH (FOLDING)

Job Number: 32716

Part Number: D412630034

Job Number:



Seq. #:

Machine Or Operation:

Description :

1 AN4C6A Bolt

26.0

AN4C10A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Bolt

Pick: Packing Kit

Qty Part Number

Description

Batch

1 AN4C10A

Bolt

M100273 ✓ SD

27.0

AN4C15A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Bolt

Pick: Packing Kit

Qty Part Number

Description

Batch

2 AN4C15A

Bolt

M102959 ✓ SD ✓

28.0

AN4C7A

Eyebolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Eyebolt

Pick: Packing Kit

Qty Part Number

Description

Batch

1 AN4C7A

Eyebolt

M101711 ✓ SD

29.0

AN5C15A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Bolt

Pick: Packing Kit

Qty Part Number

Description

Batch

2 AN5C15A

Bolt

M100229 ✓ SD
M101290 ✓

30.0

NAS1515H4

Washer



Comment: Qty.: 7.0000 Each(s)/Unit Total : 42.0000 Each(s)

Washer

Pick: Packing Kit

Qty Part Number

Description

Batch

*H7

NAS1515H4

Washer

M101428 ✓ 7/7/2B SD ✓

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 07/07/23
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 5/31/2007 7:23:03 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS STEP RH (FOLDING)

Job Number: 32716

Part Number: D412630034

Job Number:



Seq. #:

Machine Or Operation:

Description:

31.0

NAS1515H5

Washer



Comment: Qty.: 7.0000 Each(s)/Unit Total: 42.0000 Each(s)

Washer

Pick: Packing Kit

Qty	Part Number	Description
7	NAS1515H5	Washer

Batch

M104885 ✓

SD ✓

32.0

MS210434

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total: 24.0000 Each(s)

Nut

Pick: Packing Kit

Qty	Part Number	Description
4	MS21043-4	Nut

Batch

M104936 ✓

SD ✓

33.0

MS210435

Nut



Comment: Qty.: 3.0000 Each(s)/Unit Total: 18.0000 Each(s)

Nut

Pick: Packing Kit

Qty	Part Number	Description
3	MS21043-5	Nut

Batch

M10418 ✓

7/7/23 SD (5) ✓

34.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

6/7/23 (5) ✓

35.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-630-034

Location: A

PPP Rev: A

6/7/23 (5) ✓

36.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

7/7/23 (5) ✓

Job Completion



W 7/7/23

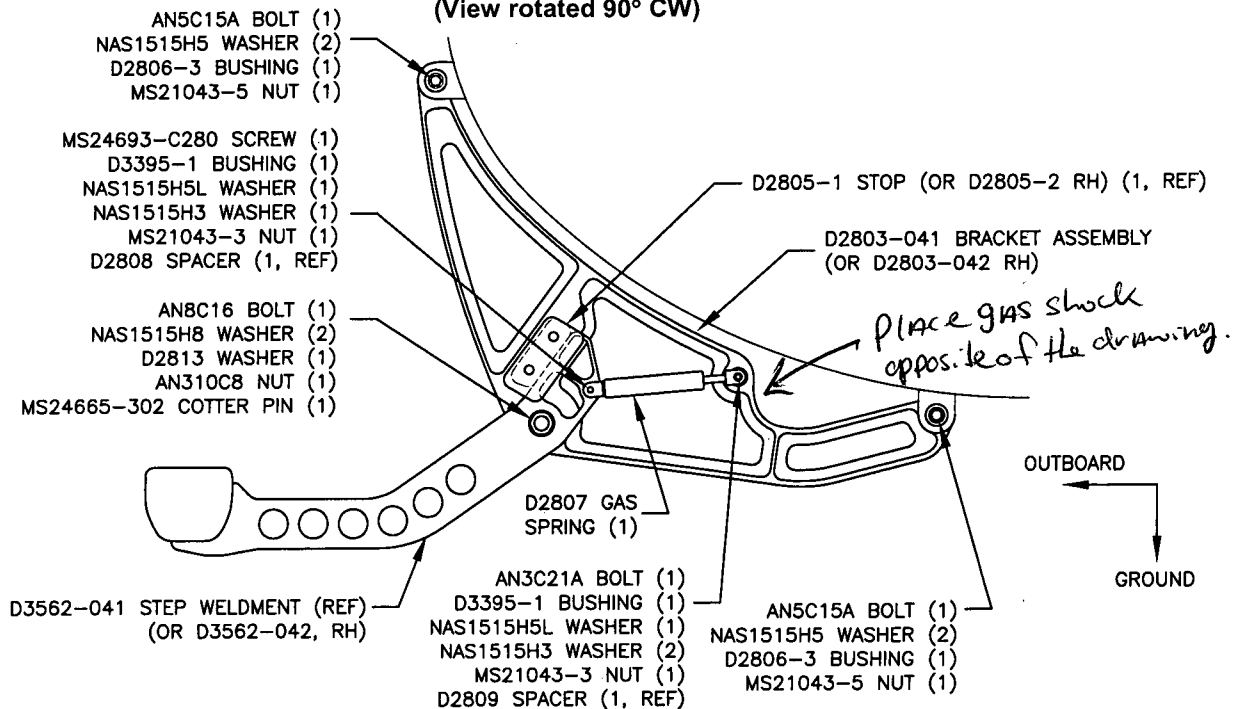
W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Action Description	Sign & Date			

NOTE: Date & initial all entries

D412-630-033/-034 Heli-Access-Step™ Installation**FIGURE 14 – STA 84.29 for D412-630-033/-034 Heli-Access-Step™ Installation**
(View rotated 90° CW)**FIGURE 15 – STA 155.06 for D412-630-033/-034 Heli-Access-Step™ Installation**
(View rotated 90° CW)